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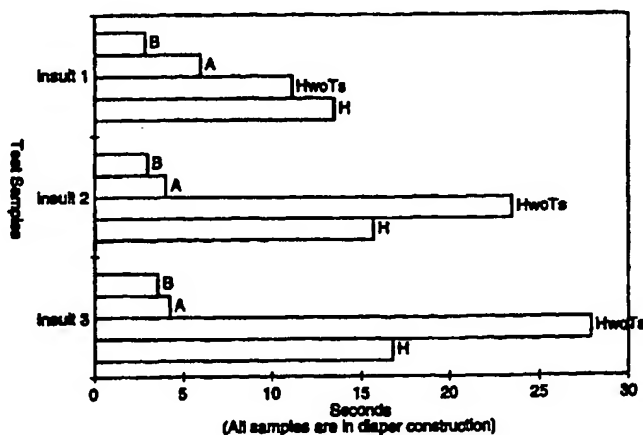
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(54) Title: FOAMED POLYMER AND PROCESS FOR PRODUCTION THEREOF



(57) Abstract

A foamed isocyanate-based polymer having a cellular structure and containing a superabsorbent material, the polymer being capable of: (i) absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25 °C, and (ii) retaining at least about 20 times its weight of absorbed aqueous fluid which is bound to the superabsorbent material. A process for producing a foamed isocyanate-based polymer comprising the steps of: providing a substantially uniform mixture comprising an isocyanate, an active hydrogen-containing compound and a superabsorbent material, the superabsorbent material being capable of absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature in the range of from about 20° to about 25 °C; adding to the substantially uniform mixture an aqueous blowing agent and a catalyst to form a reaction mixture; and expanding the reaction mixture to produce the foamed isocyanate-based polymer; wherein the active hydrogen-containing compound comprises from about 10 % to 100 % by weight of a hydrophilic active hydrogen-containing compound and from 0 to about 90 % by weight a non-hydrophilic active hydrogen-containing compound. The foamed isocyanate-based polymer is ideally suitable for use in an absorption layer in a personal hygiene device.

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**FOAMED POLYMER AND PROCESS
FOR PRODUCTION THEREOF**

TECHNICAL FIELD

- 5 The present invention relates to a foamed polymer and to a process for production thereof. More particularly, the present invention relates to a foamed isocyanate-based polymer (e.g. polyurethane foam, polyurea foam, polyisocyanurate foam, etc.) and a process for production thereof.

10 **BACKGROUND ART**

Isocyanate-based polymers are known in the art. Generally, those of skill in the art understand isocyanate-based polymers to be polyurethanes, polyureas, polyisocyanurates and mixtures thereof.

- 15 It is also known in the art to produce foamed isocyanate-based polymers. Indeed, one of the advantages of isocyanate-based polymers compared to other polymer systems is that the chemistry can be used to achieve desired product properties in situ.

- 20 One of the conventional ways to produce a polyurethane foam is known as the "one-shot" technique. In this technique, the isocyanate, a suitable polyol, a catalyst, water (which acts as a primary blowing agent and can optionally be supplemented with one or more secondary organic blowing agents) and other additives are mixed together at once using, for example, a mechanical or impingement mixer. Generally, if one were to produce a polyurea, the polyol would be replaced with a suitable polyamine. A
25 polyisocyanurate may result from cyclotrimerization of the isocyanate component. Urethane-modified polyureas or polyisocyanurates are known in the art. In either scenario, the reactants would be intimately mixed quickly using a suitable mixer.

- 30 Another technique for producing foamed isocyanate-based polymers is known as the "prepolymer" technique. In this technique, a prepolymer of polyol and isocyanate (in the case of a polyurethane) are reacted in an inert atmosphere to form a liquid polymer terminated with isocyanate groups. To

produce the foamed polymer, the prepolymer is thoroughly mixed with water and a polyol (in the case of producing a polyurethane) or a polyamine (in the case of producing a polyurea) in the presence of a catalyst or a cross-linker. In certain cases, the foamed polymer can be produced by reaction of the prepolymer can be produced by reaction of the prepolymer with water and catalyst.

As is known by those of skill in the art, many conventional isocyanate-based foams are non-hydrophilic (i.e. relatively hydrophobic). Such foams generally have an aversion to aqueous fluids. Practically, this results in such foams being unable to absorb or pick up significant quantities of aqueous fluids (e.g. the foams will float on water) other than by mechanical entrainment. Accordingly, such foams are virtually never used in an application in which significant aqueous fluid absorption is a desired feature.

Heretofore, the prior art has endeavoured to produce hydrophilic isocyanate-based foams (i.e. foams which are able to absorb or pick up significant quantities of aqueous fluids) using two general approaches.

The first approach has been to confer hydrophilicity to an otherwise hydrophobic foam by the use of specific active hydrogen-containing compound (e.g. polyol in the case of polyurethane) and/or another additive to the reaction system. For example, it is known that use of a polyol commercially available from Olin Corporation under the tradename POLY-G-X-609® in an otherwise conventional formulation will result in production of a hydrophilic polyurethane foam. See also, for other examples of this approach, United States patents 3,781,231 (Janssen et al.) and 3,799,898 (Lamplugh et al.), and British patent 1,354,576 (Fritz Nauer & Co.), the contents of each of which are hereby incorporated by reference. The resultant foam is hydrophilic in the sense that it will absorb or pick up an aqueous fluid (e.g. when the foam is immersed in a body of water, it will be at least partially or totally submerged). However, the resultant foam is incapable of retaining substantial quantities of any absorbed or picked up aqueous fluid (e.g. in the previous example, when the at least partially or totally submerged foam is removed from the body of water, the absorbed water will immediately begin to drain

from the foam matrix). The result of this is that, previously known hydrophilic foams produced according to the first approach are unsuitable for use in applications where aqueous fluid absorption and retention are required (e.g. disposable diapers, disposable training pants, sanitary napkins, incontinence devices and other personal hygiene products, general purpose sponges, surgical sponges, absorbent devices for agricultural/horticultural applications, pest control, chemical spill blockage and the like).

The second approach has been to combine a non-hydrophilic (i.e. relatively hydrophobic) isocyanate-based foam with a superabsorbent material. Generally, a material is considered superabsorbent if it will absorb a multiple of its weight of a fluid. Thus, most known superabsorbent materials are capable of absorbing at least about ten times, preferably at least about twenty times, their in weight of an aqueous fluid. For examples of this approach, see United States patents 3,900,030, 4,394,930 (Korpman), 4,731,391 (Garvey) and 4,985,467 (Kelly et al.), and published Japanese patent applications 55/168,104 and 57/92,032, the contents of each of which are hereby incorporated by reference. A general disadvantage of this approach is that aqueous fluid absorption occurs initially via the surface of the foam, the superabsorbent material therein expands thereby retarding migration of the fluid to the interior of the foam with the result that the amount of aqueous fluid absorption or pick up is significantly limited. The principal reason for this phenomenon is that the foam matrix has a cellular structure which has cells that are closed (this inhibits fluid absorption) or open (this allows fluid absorption). As is known in the art, an open cellular structure is one wherein a cellular structure is maintained and is open by virtue of providing fissures or cracks in the windows between the cell struts. The fissures or cracks result in cells which are effectively interconnected as regards fluid absorption or pick up. Kelly et al. is noteworthy since it endeavours to overcome the general disadvantage of this approach discussed above. Specifically, the purported novelty in Kelly et al. is to produce a cellular structure containing the superabsorbent material and subjecting it to a thermal reticulation process with the result that the windows between the struts of a conventional cellular

structure (closed or open) are completely destroyed allowing for improved fluid access to the interior of foam. As is known in the art, reticulation is a post-treatment step which will add potential variability to the overall process. A disadvantage of Kelly et al. is that, in return for an extra complicated and expensive process step, the gain in fluid absorption or pick up is relatively modest, at best, and only at certain loadings of superabsorbent material.

In light of these difficulties in the prior art, it would be advantageous to have a foamed isocyanate-based polymer which is both hydrophilic and capable of retaining a substantial quantity of aqueous fluid which is absorbed or picked up. It would be further advantageous if such a foam could be produced in a relatively uncomplicated way and possessed generally reproducible physical properties.

DISCLOSURE OF THE INVENTION

It is an object of the present invention to provide a novel foamed isocyanate-based polymer which obviates or mitigates one or more of the above-identified deficiencies of the prior art.

It is an object of the present invention to provide a novel process for producing such a foamed isocyanate-based polymer.

It is another object of the present invention to provide a novel personal hygiene device incorporating such a foamed isocyanate-based polymer.

Accordingly, in one of its aspects, the present invention provides a foamed isocyanate-based polymer having a cellular structure and comprising a superabsorbent material, the polymer being capable of: (i) absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining at least about 20 times its weight of absorbed aqueous fluid which is bound to the superabsorbent material.

In another of its aspects, the present invention provides a foamed polyurethane polymer comprising poly(acrylic acid alkali metal salt) in an amount in the range of from about 55 to about 65 parts by weight of polyol used to produce the foamed polyurethane polymer, the polymer being capable

of: (i) absorbing from about 35 to about 65 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining from about 30 to about 55 times its weight of absorbed aqueous fluid which is bound to the poly(acrylic acid alkali metal salt).

5 In yet another of its aspects, the present invention provides a process for producing a foamed isocyanate-based polymer comprising the steps of:

 providing a substantially uniform mixture comprising an isocyanate, an active hydrogen-containing compound and a superabsorbent material, the superabsorbent material being capable of absorbing at least about 20 times its
10 weight of an aqueous fluid maintained at a temperature in the range of from about 20° to about 25°C;

 adding to the substantially uniform mixture an aqueous blowing agent and a catalyst to form a reaction mixture; and

 expanding the reaction mixture to produce the foamed isocyanate-based
15 polymer;

 wherein the active hydrogen-containing compound comprises from about 10% to 100% by weight of a hydrophilic active hydrogen-containing compound and from 0 to about 90% by weight a non-hydrophilic active hydrogen-containing compound.

20 In an alternate embodiment to the present process, a process is provided for producing a foamed isocyanate-based polymer comprising the steps of:

 providing a substantially uniform mixture comprising an aqueous blowing agent, a catalyst, an active hydrogen-containing compound and a
25 superabsorbent material, the superabsorbent material being capable of absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature in the range of from about 20° to about 25°C;

 adding to the substantially uniform mixture an isocyanate to form a reaction mixture; and

30 expanding the reaction mixture to produce the foamed isocyanate-based polymer;

wherein the active hydrogen-containing compound comprises from about 10% to 100% by weight of a hydrophilic active hydrogen-containing compound and from 0 to about 90% by weight a non-hydrophilic active hydrogen-containing compound.

5 When either embodiment of the process is used to prepare a foamed polyurethane or a foamed urea-modified polyurethane, it is possible, and indeed preferred, to use a single polyol or a mixture of polyols which possesses an overall ethylene oxide content in the range of from about 15 to about 80, preferably from about 20 to about 70, more preferably from about
10 35 to about 70, most preferably from about 50 to about 65, percent by weight, the remainder comprised of other polyoxyalkylene groups such as propylene oxide, butylene oxide or mixtures thereof.

 In yet another of its aspects, the present invention provides a personal hygiene device having a bodily fluid absorbent layer consisting essentially of
15 a foamed isocyanate-based polymer having a cellular structure and containing a superabsorbent material, the polymer being capable of: (i) absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining at least about 20 times its weight of absorbed aqueous fluid which is bound to the superabsorbent
20 material.

 In yet another of its aspects, the present invention provides a personal hygiene device having a bodily fluid absorbent layer consisting essentially of a foamed polyurethane polymer comprising poly(acrylic acid alkali metal salt) in an amount in the range of from about 55 to about 65 parts by weight of
25 polyol used to produce the foamed polyurethane polymer, the polymer being capable of: (i) absorbing from about 35 to about 65 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining from about 30 to about 55 times its weight of absorbed aqueous fluid which is bound to the poly(acrylic acid alkali metal salt).

30 As used throughout this specification, the term "isocyanate-based polymer" is intended to mean, inter alia, polyurethane, polyurea and polyisocyanurate.

It has been discovered that, by combining reactants necessary to produce a hydrophilic isocyanate-based foam with a superabsorbent material, a superabsorbent foam having surprising, unexpected and significantly enhanced aqueous fluid absorption/pick up (the terms absorption and pick up are used interchangeably throughout the present specification) and retention properties can be made. More specifically, many of the present foamed isocyanate-based polymers exhibit synergistic improvements in aqueous fluid absorption and retention properties compared to prior art hydrophilic foams which contain no superabsorbent material (i.e. the first approach of the prior art discussed above) and hydrophobic foams which contain superabsorbent materials (i.e. the second approach of the prior art discussed above). To the knowledge of the Applicant, prior to the present invention, foamed isocyanate-based polymers having such enhanced aqueous fluid absorption and retention properties were unknown.

While applications for such a foamed isocyanate-based polymer will be immediately apparent to those of skill in the art, it is believed that the present foamed isocyanate-based polymer is particularly useful in personal hygiene devices such as disposable diapers, disposable training pants, sanitary napkins, incontinence pads, bandage gauze and the like. More particularly, it is contemplated that the present foamed isocyanate-based polymer presents a significantly more cost effective alternative to the conventional superabsorbent material/pulp mixtures used in current disposable diapers. The significant cost savings is realized in both reduced component costs and equipment costs.

BRIEF DESCRIPTION OF THE DRAWINGS

Embodiments of the present invention will be described with reference to the accompanying drawings, in which:

Figures 1 and 2 illustrate a graph of fluid absorption versus time for various samples; and

Figure 3 illustrates the results of a strike through test for fluid absorption rate for various samples.

BEST MODE FOR CARRYING OUT THE INVENTION

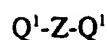
The present invention is related to, inter alia, a foamed isocyanate-based polymer comprising a superabsorbent material and to a process for production thereof. Generally, the present foamed isocyanate-based polymer is selected from the group comprising polyurethane foam, polyurea foam, polyisocyanurate foam, urea-modified polyurethane foam, urethane-modified polyurea foam, urethane-modified polyisocyanurate foam and urea-modified polyisocyanurate foam. The preferred foamed isocyanate-based polymer is selected from the group consisting of polyurethane foam and urea-modified polyurethane foam. The most preferred isocyanate-based polymer is polyurethane foam. As is known in the art, the term "modified", when used in conjunction with a polyurethane, polyurea or polyisocyanurate means that up to 50% of the polymer backbone forming linkages have been substituted.

The first step in the present process comprises providing a substantially uniform mixture comprising an isocyanate, an active hydrogen-containing compound and a superabsorbent material, the superabsorbent material being capable of absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature in the range of from about 20° to about 25°C.

The isocyanate suitable for use in the substantially uniform mixture is not particularly restricted and the choice thereof is within the purview of a person skilled in the art. Generally, the isocyanate compound suitable for use may be represented by the general formula:



wherein i is an integer of two or more and Q is an organic radical having the valence of i . Q may be a substituted or unsubstituted hydrocarbon group (e.g. an alkylene or arylene group). Moreover, Q may be represented by the general formula:



wherein Q' is an alkylene or arylene group and Z is chosen from the group comprising -O-, -O-Q'-, -CO-, -S-, -S-Q'-S- and -SO₂-. Examples of isocyanate compounds which fall within the scope of this definition include hexamethylene diisocyanate, 1,8-diisocyanato-p-methane, xylyl diisocyanate,
 5 (OCNCH₂CH₂CH₂OCH₂O)₂, 1-methyl-2,4-diisocyanatocyclohexane, phenylene diisocyanates, toluene diisocyanates, chlorophenylene diisocyanates, diphenylmethane-4,4'-diisocyanate, naphthalene-1,5-diisocyanate, triphenylmethane-4,4',4''-triisocyanate and isopropylbenzene-alpha-4-diisocyanate.

In another embodiment, Q may also represent a polyurethane radical
 10 having a valence of i. In this case Q(NCO)_i is a compound which is commonly referred to in the art as a prepolymer. Generally, a prepolymer may be prepared by reacting a stoichiometric excess of an isocyanate compound (as defined hereinabove) with an active hydrogen-containing compound (as defined hereinafter), preferably the polyhydroxyl-containing
 15 materials or polyols described below. In this embodiment, the polyisocyanate may be, for example, used in proportions of from about 30 percent to about 200 percent stoichiometric excess with respect to the proportion of hydroxyl in the polyol. The prepolymer may then be reacted with a polyol, aqueous blowing agent (water), catalyst and, optionally, other additives, to produce a
 20 polyurethane foam or an amine to produce a polyurea-modified polyurethane.

In another embodiment, the isocyanate compound suitable for use in the process of the present invention may be selected from dimers and trimers of isocyanates and diisocyanates, and from polymeric diisocyanates having the general formula:

25



wherein both i and j are integers having a value of 2 or more, and Q'' is a polyfunctional organic radical, and/or, as additional components in the
 30 reaction mixture, compounds having the general formula:



wherein i is an integer having a value of 1 or more and L is a monofunctional or polyfunctional atom or radical. Examples of isocyanate compounds which fall with the scope of this definition include ethylphosphonic diisocyanate, phenylphosphonic diisocyanate, compounds which contain a =Si-NCO group,
5 isocyanate compounds derived from sulfonamides (QSO₂NCO), cyanic acid and thiocyanic acid.

See also for example, British patent No. 1,453,258, the contents of which are incorporated herein by reference.

Non-limiting examples of suitable isocyanates include: 1,6-
10 hexamethylene diisocyanate, 1,4-butylene diisocyanate, furfurylidene diisocyanate, 2,4-toluene diisocyanate, 2,6-toluene diisocyanate, 2,4'-diphenylmethane diisocyanate, 4,4'-diphenylmethane diisocyanate, 4,4'-diphenylpropane diisocyanate, 4,4'-diphenyl-3,3'-dimethyl methane diisocyanate, 1,5-naphthalene diisocyanate, 1-methyl-2,4-diisocyanate-5-
15 chlorobenzene, 2,4-diisocyanato-s-triazine, 1-methyl-2,4-diisocyanato cyclohexane, p-phenylene diisocyanate, m-phenylene diisocyanate, 1,4-naphthalene diisocyanate, dianisidine diisocyanate, bitoluene diisocyanate, 1,4-xylylene diisocyanate, 1,3-xylylene diisocyanate, bis-(4-isocyanatophenyl)methane, bis-(3-methyl-4-isocyanatophenyl)methane,
20 polymethylene polyphenyl polyisocyanates and mixtures thereof. A more preferred isocyanate is selected from the group comprising 2,4-toluene diisocyanate, 2,6-toluene diisocyanate and mixtures thereof, for example, a mixture comprising from about 75 to about 85 percent by weight 2,4-toluene diisocyanate and from about 15 to about 25 percent by weight 2,6-toluene
25 diisocyanate. Another more preferred isocyanate is selected from the group comprising 2,4'-diphenylmethane diisocyanate, 4,4'-diphenylmethane diisocyanate and mixtures thereof. The most preferred isocyanate is a mixture comprising from about 15 to about 25 percent by weight 2,4'-diphenylmethane diisocyanate and from about 75 to about 85 percent by weight 4,4'-
30 diphenylmethane diisocyanate. An example of such an isocyanate is commercially available from Imperial Chemical Industries under the

tradename Rubinate M and from The Dow Chemical Company under the tradename PAPI 4027.

The active hydrogen-containing compound used in the uniform mixture comprises from about 10% to 100% by weight of a hydrophilic active
5 hydrogen-containing compound and from 0 to about 90% by weight a non-hydrophilic active hydrogen-containing compound. Preferably, the active hydrogen-containing compound comprises from about 20% to about 90%, more preferably from about 40% to about 90%, most preferably from about 60% to about 80%, by weight of a hydrophilic active hydrogen-containing
10 compound and from about 10% to about 80%, more preferably from about 10% to about 60%, most preferably from about 20% to about 30%, by weight a non-hydrophilic active hydrogen-containing compound.

Preferably, the hydrophilic active hydrogen-containing compound is a hydrophilic polyol. As is known in the term "hydrophilic polyol" is intended
15 to mean a polyol which confers hydrophilicity to the foam product. Ideally the hydrophilic polyol has a molecular weight in the range of from about 1500 to about 6000. Preferably, the hydrophilic polyol is selected from the group consisting of diols, triols, tetrols and mixtures thereof, each of which contain polyoxyalkylene groups, the polyoxyalkylene groups comprising at least about
20 25, more preferably from about 40 to about 85, most preferably from about 55 to about 85, percent by weight of ethylene oxide. As is known in the art, the balance of the polyoxyalkylene groups is conventionally made up of one or both of propylene oxide and butylene oxide, preferably solely propylene oxide. A particularly preferred hydrophilic polyol is commercially available
25 from The Dow Chemical Company under the tradename CP1421. Another preferred hydrophilic polyol is commercially available from Arco under the tradename Arcol 2580. Yet another preferred hydrophilic polyol is commercially available from BASF Corporation under the tradename Pluracol 593.

30 Alternatively, if it is desired to produce a polyurea, the active hydrogen-containing compound may be derived from a hydrophilic polyol as

described above which as been reacted or capped with an amine. Such amination is within the purview of a person skilled in the art.

The non-hydrophilic active hydrogen-containing compound, if present, is selected from the group consisting of non-hydrophilic polyols, polyamines, polyamides, polyimines, polyolamines and mixtures thereof.

If the process is utilized to produce a polyurethane foam, the non-hydrophilic active hydrogen-containing compound is typically a non-hydrophilic polyol. Generally, if such non-hydrophilic polyols contain or are based on ethylene oxide, the ethylene oxide will be present in amounts of less than about 20% by weight. The choice of such a polyol is not particularly restricted and is within the purview of a person skilled in the art. For example, the polyol may be a hydroxyl-terminated compound selected from the group comprising polyether, polyester, polycarbonate, polydiene and polycaprolactone. The polyol may be selected from the group comprising hydroxyl-terminated polyhydrocarbons, hydroxyl-terminated polyformals, fatty acid triglycerides, hydroxyl-terminated polyesters, hydroxymethyl-terminated polyesters, hydroxymethyl-terminated perfluoromethylenes, polyalkylene ether glycols, polyalkylenearyleneether glycols and polyalkyleneether triols. The polyol may also be selected from the group comprising adipic acid-ethylene glycol polyester, poly(butylene glycol), poly(propylene glycol) and hydroxyl-terminated polybutadiene - see, for example, British patent No. 1,482,213, the contents of which are incorporated herein by reference. Preferably, such a polyol has a molecular weight in the range of from about 200 to about 10,000, more preferably from about 1,500 to about 4,300, most preferably from about 3,000 to about 4,100. Ideally, such a polyol would contain predominantly secondary hydroxyl groups.

As discussed above, it is possible to utilize a prepolymer technique to produce a polyurethane foam within the scope of the present invention. In one embodiment, it is contemplated that the prepolymer be prepared by reacting an excess of isocyanate with a hydrophilic polyol (as discussed above). The prepolymer could then be reacted with a non-hydrophilic polyol (as discussed above) to produce a polyurethane foam or an amine to produce a polyurea-

modified polyurethane. In another embodiment, it is contemplated that the prepolymer be prepared by reacting an excess of isocyanate with a non-hydrophilic polyol (as discussed above). The prepolymer could then be reacted with a hydrophilic polyol (as discussed above) to produce a polyurethane foam. In yet another embodiment, if a single polyol provides a desirable overall ethylene oxide content (as discussed above), the prepolymer can be prepared and reacted to produce polyurethane using the same polyol.

If the process is utilized to produce a polyurea-modified polyurethane foam, the non-hydrophilic active hydrogen-containing compound comprises, at least in part, compounds wherein hydrogen is bonded to nitrogen. Preferably such compounds are selected from the group comprising polyamines, polyamides, polyimines and polyolamines, more preferably polyamines. Non-limiting examples of such compounds include primary and secondary amine terminated polyethers. Preferably such polyethers have a molecular weight of greater than about 1500, a functionality of from 2 to 6, and an amine equivalent weight of from about 200 to about 6,000. Such amine terminated polyethers are typically made from an appropriate initiator to which a lower alkylene (e.g. ethylene, propylene, butylene and mixtures thereof) oxide is added with the resulting hydroxyl terminated polyol being subsequently aminated. If two or more alkylene oxides are used, they may be present either as random mixtures or as blocks of one or the other polyether. For ease of amination, it is especially preferred that the hydroxyl groups of the polyol be essentially all secondary hydroxyl groups. Typically, the amination step replaces the majority but not all of the hydroxyl groups of the polyol.

If the process is used to produce a polyurethane foam or a urea-modified polyurethane, it is possible, and indeed preferred, to use a single polyol or a mixture of polyols which possesses an overall ethylene oxide content in the range of from about 15 to about 80, preferably from about 20 to about 70, more preferably from about 35 to about 70, most preferably from about 50 to about 65, percent by weight, the remainder comprised of other polyoxyalkylene groups such as propylene oxide, butylene oxide or mixtures

thereof. While a preferred and practical method of achieving such an overall ethylene oxide content is by blending a hydrophilic polyol and a non-hydrophilic polyol as described hereinabove, it will be appreciated that it is possible and likely even preferred to use a single polyol which possesses substantially the same ethylene oxide content as a mixture of a hydrophilic polyol and a non-hydrophilic polyol. Such a polyol is disclosed in copending United States patent application S.N. 08/576,695, filed December 21, 1995, the contents of which are hereby incorporated by reference.

The superabsorbent material used in the uniform mixture is capable of absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature in the range of from about 20° to about 25°C. Preferably, the superabsorbent material is a synthetic polymer such as a cellulosic polymer or a polymer of at least one of an acrylic monomer and vinyl monomer, although it is possible to use other materials such as copolymers of maleic acid and isobutylene (typically in fiber form), and polyethers. A non-limiting example of a suitable cellulosic polymer is a carboxymethyl cellulose and alkali metal salts thereof. A non-limiting example of a suitable polymer of at least one of an acrylic monomer and vinyl monomer may be selected from the group consisting of polyvinylpyrrolidone, sulfonated polystyrene, polysulfethyl acrylate, poly(2-hydroxyethylacrylate), polyacrylamide, poly(acrylic acid) and alkali metal salts thereof, poly(acrylic acid alkali metal salt), starch modified polyacrylic acid and alkali metal salts thereof, poly(starch modified acrylic acid alkali metal salt), hydrolyzed polyacrylonitrile and alkali metal salts thereof, poly(hydrolyzed polyacrylonitrile alkali metal salt), poly(vinyl alcohol acrylic acid alkali metal salt), salts thereof and mixtures thereof. Most preferably, the superabsorbent material is a poly(acrylic acid alkali metal salt) such as poly(sodium acrylate).

While the amount of superabsorbent material used in the initial step in the present process is not particularly restricted, it is preferred that the superabsorbent material be present in an amount up to about 150 parts by weight per hundred parts by weight of active hydrogen-containing compound used to produce the foamed isocyanate-based polymer. More preferably, the

superabsorbent material is present in an amount in the range of from about 20 to about 80 parts, even more preferably from about 35 to about 75, most preferably from about 55 to about 65, by weight per hundred parts by weight of active hydrogen-containing compound used to produce the foamed isocyanate-based polymer. Of course, as improvements are made to superabsorbent materials, it is contemplated that the loading level required in the present foamed isocyanate-based polymer may be reduced while maintaining a given absorption and retention.

The manner by which the uniform mixture of isocyanate, active hydrogen-containing compound and superabsorbent material is prepared is not particularly restricted. Thus, it is possible to preblend the components in a separate tank which is then connected to a suitable mixing device for mixing with the aqueous blowing agent and catalyst. Alternatively, it is possible to preblend the superabsorbent material with the active hydrogen-containing compound. This preblend could then be fed to a suitable mixhead which would also receive independent streams of the isocyanate, the aqueous blowing agent and the catalyst (the aqueous blowing agent and catalyst streams could be combined prior to the mixhead, if desired). In this embodiment, care would have to be taken to design the mixhead to ensure that the preblend and isocyanate streams are adequately mixed at the time that the aqueous blowing agent and catalyst stream(s) are added.

As is known in the art, aqueous blowing agents such as water can be used as a reactive blowing agent in the production of foamed isocyanate-based polymers. Specifically, water reacts with the isocyanate forming carbon dioxide which acts as the effective blowing agent in the final foamed polymer product. Optionally, organic blowing agents may be used in conjunction with the aqueous blowing agent, although the use of such blowing agents is generally being curtailed for environmental considerations. It is known in the art that the amount of water used as a blowing agent in the preparation of a foamed isocyanate-based polymer is conventionally in the range of from about 0.5 to as high as about 20 or more parts by weight, preferably from about 1.0 to about 5.0 parts by weight, based on 100 parts by weight of the total active

hydrogen-containing compound content in the reaction mixture. Since the amount of water used in the production of a foamed isocyanate-based polymer is limited by the fixed properties expected in the foamed polymer, it may be necessary, in certain circumstances, to utilize a substantially inert liquid
5 extenders when high loadings of filler material are contemplated. Non-limiting examples of suitable liquid extenders include halogenated hydrocarbons and high molecular weight hydrocarbons.

The catalyst added to the uniform mixture of isocyanate, active hydrogen-containing compound and superabsorbent material is a compound
10 capable of catalyzing the polymerization reaction. Such catalysts are known, and the choice and concentration thereof is within the purview of a person skilled in the art. See for example United States patents 4,296,213 and 4,518,778, the contents of each of which is incorporated herein by reference. Non-limiting examples of suitable catalysts include tertiary amines and/or
15 organometallic compounds. Additionally, as is known in the art, when the objective is to produce an isocyanurate, a Lewis acid must be used as the catalyst, either alone or in conjunction with other catalysts. Of course it will be understood by those skilled in the art that a combination of two or more catalysts may be suitably used.

20 While the foregoing discussion relates to the one of the process embodiments of the present invention (i.e. addition of catalyst/water to uniform mixture of isocyanate, active hydrogen-containing compound and superabsorbent material), it is equally applicable to the second of the process embodiments of the present invention (i.e. addition of isocyanate to uniform
25 mixture of catalyst/water, active hydrogen-containing compound and superabsorbent material) as regards choice and concentration of the various ingredients. In other words, the foregoing discussion regarding choice and concentration of various ingredients can be readily applied to a "one-shot" process wherein the resin stream comprises catalyst, water, active hydrogen-
30 containing compound and superabsorbent material, to which is added the isocyanate.

As will be clearly understood by those of skill in the art, it is contemplated that conventional additives in the isocyanate-based polymer art be used in the process. Non-limiting examples of such additives include: surfactants (e.g. organo-silicone compounds available under the tradename L-
5 540 from O.S.I.), cell openers (e.g. silicone oils), extenders (e.g. halogenated paraffins commercially available as Cereclor S45), cross-linkers (e.g. low molecular weight reactive hydrogen-containing compositions), pigments/dyes, flame retardants (e.g. halogenated organo-phosphoric acid compounds), inhibitors (e.g. weak acids), nucleating agents (e.g. diazo compounds), anti-
10 oxidants, plasticizers/stabilizers (e.g. sulphonated aromatic compounds) and biocides. The amounts of these additives conventionally used would be within the purview of a person skilled in the art.

A particularly preferred class of additives which may be used herein is that of fillers. The particular advantage is that various fillers such as pulp
15 and ground post-consumer goods (e.g. tire, reaction injected molded parts, reinforced reaction injection mold parts, off-specification personal hygiene devices, etc.) is that they can be effectively recycled in the present foamed isocyanate-based polymer with little or no compromise of aqueous fluid absorption and retention.

20 Once the aqueous blowing agent and catalyst have been added to the uniform mixture of isocyanate, active hydrogen-containing compound and superabsorbent material, a reaction mixture is formed. This reaction mixture is then expanded to produce the present foamed isocyanate-based polymer. As will be apparent to those of skill in the art, the process of the present
25 invention is useful in the production of slab foam, molded articles, carpet underlay and the like. Thus, as will be apparent to a person skilled in the art, the manner by which expansion of the reaction mixture is effected will be dictated by the type of foam being produced.

The product of the present process is a foamed isocyanate-based
30 polymer having a cellular structure and containing a superabsorbent material, the polymer being capable of: (i) absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about

25°C, and (ii) retaining at least about 20 times its weight of absorbed aqueous fluid which is bound to the superabsorbent material. Preferably the polymer is capable of: (i) absorbing at from about 20 to about 100, more preferably from about 20 to about 80, most preferably from about 35 to about 65, times
5 its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining from about 20 to about 90, more preferably from about 20 to about 70, most preferably from about 30 to about 55, times its weight of absorbed aqueous fluid which is bound to the superabsorbent material.

10 The ability of the foamed isocyanate-based polymer to absorb aqueous liquid (e.g. water) can be assessed by following protocol: (i) weigh test sample of foamed isocyanate-based polymer (W_i), (ii) immerse test sample in an aqueous fluid maintained at a temperature of from about 20° to about 25°C for a period of at least 30 minutes, (iii) remove test sample from
15 aqueous fluid and maintained on drip screen or similar device for 3 minutes, (iv) weigh test sample (W_r), and (iv) calculate $(W_r - W_i)/W_i$ and report as the amount of aqueous fluid absorbed as a multiple of the weight of the original test sample of foamed isocyanate-based polymer (W_i) (another way in which to report the results is as units mass of aqueous liquid absorbed per unit mass
20 of foam). The ability of the foamed isocyanate-based polymer to retain aqueous liquid can be assessed by conducting the absorption protocol and the following subsequent steps: (v) compress the test sample containing absorbed aqueous fluid until no more aqueous fluid can be forcibly expelled (e.g. at a compressive force of at least about 1.0 psi, more preferably at least about
25 1.13 psi) from the test sample, (vi) weigh test sample (W_r), and (iv) calculate $(W_r - W_i)/W_i$ and report as the amount of aqueous fluid retained as a multiple of the weight of the original test sample of foamed isocyanate-based polymer (W_i) (another way in which to report the results is as units mass of aqueous liquid retained per unit mass of foam). Thus, the two protocols distinguish
30 between aqueous fluid which is physically and chemically bound to the foam (i.e. absorbed) and aqueous fluid which only chemically bound to the foam (i.e. retained).

Thus, the retention properties of the present foamed isocyanate-based polymer mimic the retention properties which are desirable in a principal practical application of the present invention. Specifically, if the present foam product is used in the core of a diaper, the aqueous fluid retention properties referred to above are advantageous since they are predictive of a diaper core which will absorb, inter alia, urine while mitigating against significant amounts of absorbed urine being squeezed out of the core against the skin of the child or leaking out of the diaper.

The type of superabsorbent material and the amount thereof present in the foamed isocyanate-based polymer is as discussed hereinabove in regard to the present process.

Thus, as will be appreciated by those of skill in the art, the foam product of the present invention having advantageous aqueous fluid (e.g. water) absorption and retention properties is the direct product of polymerization and expansion. In other words, the advantageous properties of the foam product of the present invention are not dependent on any specific, complicated and expensive reticulation (or other post-treatment) step such as taught by Kelly et al. discussed above. Those of skill in the art will recognize that the foam product of the present invention is not a thermally reticulated product - i.e. the foam product of the present invention is non-reticulated. Rather, the foam product of the present invention is a cellular material having an open cell structure (i.e. cells with cracked or broken membranes between cell struts as discussed above) as opposed to a skeletal matrix or structure as taught by Kelly et al.

The present foamed isocyanate-based polymer preferably has a density of from about 1.0 pcf to about 15.0 pcf, more preferably from about 1.0 pcf to about 12.0 pcf, even more preferably from about 1.0 pcf to about 8.0 pcf, most preferably from about 1.5 pcf to about 5.0 pcf.

Embodiments of the present invention will now be described with reference to the following Examples which should not be construed as limiting the scope of the invention. The term "pbw" used in the Examples refers to parts by weight.

In the Examples the following compounds were used:

1. DABCO-T16, a polymerization catalyst commercially available from Air Products and Chemicals, Inc.;
1. Z65, a tertiary amine catalyst commercially available under the
5 trade name JEFFCAT from Huntsman Corporation;
2. TECOSTAB B8202, a surfactant commercially available from Goldschmidt Chemical Corporation;
3. VORANOL CP1421, a hydrophilic polyether polyol having a
molecular weight of approximately 5,000 and an ethylene oxide content of
10 approximately 80% by weight, available from The Dow Chemical Company;
4. Pluracol 593, a hydrophilic polyether polyol having a
molecular weight of approximately 5,000 and an ethylene oxide content of
approximately 75% by weight, available from BASF Corporation;
5. Arcol 2580, a hydrophilic polyether polyol having a molecular
15 weight of approximately 5,000 and an ethylene oxide content of approximately
75% by weight, available from Arco Corporation;
6. VORANOL 3010, a non-hydrophilic polyether polyol having
a molecular weight of approximately 3000 and an ethylene oxide content of
less than about 20% by weight, commercially available from The Dow
20 Chemical Company;
7. Arcol HS100, a non-hydrophilic polyether polyol which is a
blend of 3010 and polymeric solids, commercially available from Arco
Chemical Company;
8. TDI 80, a blend of 80% by weight 2,4-toluene diisocyanate,
25 and 20% by weight 2,6-toluene diisocyanate commercially available from
Bayer Corporation under the tradename Mondur TD-80 Grade A;
9. IM4000 and IM4500, starch grafted sodium polyacrylate
available from Hoechst Celanese Corporation;
10. ASAP 1100, a lightly crosslinked sodium polyacrylate available
30 from Chemdal Corporation;
11. SXM-75, a poly(sodium acrylate) compound available from
Stockhausen Inc.; and

12. RRIM, reinforced reaction injection molded elastomer ground to have a sieve size of -18 to +74 mesh (corresponding to a particle size of from about 210 μm about 1000 μm .

5 EXAMPLES 1-10

In these Examples, a series of hydrophilic polyurethane foams containing various amounts of superabsorbent materials were prepared. The general formulation used is provided in Table 1. The amount of superabsorbent material used in each Example is provided in Table 2.

10 TABLE 1

Ingredient	Amount (pbw)
CP1421	75.0
VORANOL 3010	25.0
B8202	1.3
15 Z65	0.5
DABCO-T16	0.05
H ₂ O	3.60
TDI 80	Amount sufficient to achieve an isocyanate index of about 1.05

20 The foams were prepared by blending the two polyols with the superabsorbent material to which was added the isocyanate to form a uniform mixture. The remaining ingredients, including the catalyst and water blowing agent, were blended separately and then added to the uniform mixture of polyols, superabsorbent material and isocyanate with adequate mixing to
25 provide a uniform reaction mixture. The reaction mixture was poured into an open container and allowed to expand to result in a polyurethane foam.

Each foam was cut to provide triplicate samples having the following dimensions: 3" x 5" x ½". The water absorption and retention properties of each of the triplicate samples was assessed using the absorption and retention protocols described above. The aqueous liquid was water and the immersion time was 60 minutes. The results, reported for each Example as the average absorption and retention, respectively, for the triplicate samples, are provided in Table 2.

TABLE 2

Example	SXM-75 (pbw)	Absorption	Retention
1	0	8.9	2.0
2	19.0	35.1	28.8
3	29.0	42.3	34.3
4	48.0	46.3	37.9
5	50.0	49.5	39.2
6	60.0	57.7	47.4
7	65.0	54.2	43.6
8	71.5	54.2	46.3
9	85.0	54.2	44.2
10	100.0	54.9	45.2

20

As will be apparent to those of skill in the art, Example 1 contains no superabsorbent material and is provided for comparison purposes only. The results clearly demonstrate that the foams produced in Examples 2-10 exhibit significantly improved absorption and retention properties compared to a hydrophilic foam which does not contain a superabsorbent material (Example 1).

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EXAMPLES 11-14

In these Examples, the methodology of Examples 1-10 was repeated except a mixture of non-hydrophilic polyols was used in place of the hydrophilic polyol/non-hydrophilic polyol mixture used in Examples 1-10.

5 Accordingly, it will be understood by those of skill in the art that Examples 11-14 are for comparative purposes only. The general formulation used in Examples 11-14 is provided in Table 3. The amount of superabsorbent material used in each Example is provided in Table 4.

TABLE 3

10	<table><tr><th>Ingredient</th><th>Amount (pbw)</th></tr><tr><td>HS100</td><td>60.0</td></tr><tr><td>VORANOL 3010</td><td>40.0</td></tr><tr><td>B8202</td><td>1.0</td></tr><tr><td>Z65</td><td>0.45</td></tr><tr><td>15 DABCO-T16</td><td>0.48</td></tr><tr><td>H₂O</td><td>3.60</td></tr><tr><td>TDI 80</td><td>Amount sufficient to achieve an isocyanate index of about 1.12</td></tr></table>	Ingredient	Amount (pbw)	HS100	60.0	VORANOL 3010	40.0	B8202	1.0	Z65	0.45	15 DABCO-T16	0.48	H ₂ O	3.60	TDI 80	Amount sufficient to achieve an isocyanate index of about 1.12
Ingredient	Amount (pbw)																
HS100	60.0																
VORANOL 3010	40.0																
B8202	1.0																
Z65	0.45																
15 DABCO-T16	0.48																
H ₂ O	3.60																
TDI 80	Amount sufficient to achieve an isocyanate index of about 1.12																

20 The foams produced in these Examples 11-14 were tested for water absorption and retention properties using the protocol described in Examples 1-10. The results are provided in Table 4 and demonstrate the importance of using a hydrophilic polyol in the formulation. Specifically, the absorption and retention properties of the foams produced in Examples 2-10 are almost twice those of the foams produced in Examples 11-14. Further, a comparison of the

25 absorption and retention properties of (i) the foam produced in Example 1 and any of the foams produced in Examples 11-14, with (ii) the foams produced

in Examples 2-10 (i.e. exemplary foams in accordance with the present invention), demonstrates that the improvements in water absorption and retention are synergistic.

TABLE 4

Example	SXM-75 (pbw)	Absorption	Retention
11	0	11.7	1.4
12	29.0	18.9	13.2
13	48.0	19.5	14.4
14	60.0	19.1	14.4

EXAMPLES 15-38

In these Examples, a series of hydrophilic polyurethane foams containing various amounts of superabsorbent materials were prepared. The general formulation used is provided in Table 5. The amount of superabsorbent material used in each Example is provided in Table 6.

For each Example, the foam was prepared by blending the two polyols with the catalyst and water blowing agent to which was added the superabsorbent material with adequate agitation to provide a uniform mixture. Thereafter, the isocyanate was added to the uniform mixture. The reaction mixture was poured into an open container and allowed to expand to result in a polyurethane foam bun having the following dimensions: 9" x 9.5" x 4". For a given composition, the procedure was repeated two times so that a total of three foam buns were produced for each Example (except Examples 33-38 where a single bun was produced).

Each foam bun was cut to provide ten samples having the following dimensions: 3" x 5" x 1/2". Thus, for a given composition thirty samples were made for testing (i.e. 3 buns x 10 samples/bun = 30 samples). The water absorption and retention properties of each of the thirty samples was assessed using the absorption and retention protocols described above. The aqueous liquid was water and the immersion time was 60 minutes. The

results, reported for each Example as the average absorption and retention, respectively, for the thirty samples of the Example, are provided in Table 6 (i.e. the average of the average absorption and retention for each lot of ten samples from a given foam bun).

5

TABLE 5

Ingredient	Amount (pbw)
CP1421	75.0
VORANOL 3010	25.0
B8202	1.3
Z65	0.5
DABCO-T16	0.05
H ₂ O	2.8
TDI 80	Amount sufficient to achieve an isocyanate index of about 1.05

10

15

As will be apparent to those of skill in the art, Example 15 contains no superabsorbent material and is provided for comparison purposes only. The results, inter alia, clearly demonstrate that: (i) the foams produced in Examples 16-38 exhibit significantly improved absorption and retention properties compared to a hydrophilic foam which does not contain a superabsorbent material (Example 15); and (ii) that foams produced in Examples 32-38 contained large amounts of superabsorbent material and exhibit very high absorption and retention properties.

20

25

TABLE 6

Example	IM4000 (pbw)	Absorption	Retention
15	0	15.1	9.0
16	20.0	30.8	22.6
17	25.0	38.7	28.9
18	30.0	40.5	31.8
19	35.0	44.2	36.2
20	40.0	44.7	36.2
21	45.0	45.4	38.2
22	50.0	46.7	39.4
23	55.0	45.6	39.7
24	60.0	47.4	41.0
25	65.0	48.1	43.4
26	70.0	47.2	41.9
27	75.0	49.2	41.9
28	80.0	50.2	44.5
29	85.0	52.1	46.5
30	90.0	52.1	47.1
31	95.0	55.3	50.1
32	100.0	54.7	49.8
33	105.0	60.4	55.7
34	110.0	67.0	61.0
35	115.0	63.4	58.1
36	120.0	63.7	57.4
37	125.0	64.63	59.9
38	130.0	70.25	65.2

EXAMPLES 39-57

The methodology used in Examples 15-38, included the formulation provided in Table 5 above, was repeated in these Examples with the exception

that the superabsorbent material used in these Examples was ASAP 1100. The amount of ASAP 1100 used in each of these Examples 39-57 is reported in Table 7, together with the results of absorption and retention testing using the protocol described hereinabove in Examples 15-38.

5 As will be apparent to those of skill in the art, Example 39 contains no superabsorbent material and is provided for comparison purposes only. The results, inter alia, clearly demonstrate that: (i) the foams produced in Examples 40-57 exhibit significantly improved absorption and retention properties compared to a hydrophilic foam which does not contain a
10 superabsorbent material (Example 39).

EXAMPLES 58-63

In these Examples, a series of hydrophilic polyurethane foams containing various amounts of hydrophilic polyol/non-hydrophilic polyol were
15 prepared. The hydrophilic polyol used was CP1421 and the non-hydrophilic polyol used was VORANOL 3010 (referred to as 3010). The general formulation used is provided in Table 8. The relative amounts of hydrophilic polyol and non-hydrophilic used in each Example is provided in Table 9.

For each Example, the foam was prepared by blending the two polyols
20 (except Example 58 where a single polyol was used) with the catalyst and water blowing agent to which was added the superabsorbent material with adequate agitation to provide a uniform mixture. Thereafter, the isocyanate was added to the uniform mixture. The reaction mixture was poured into an open container and allowed to expand to result in a polyurethane foam bun.
25 having the following dimensions: 9" x 9.5" x 4". For a given composition, the procedure was repeated two times so that a total of three foam buns were produced for each Example (except Examples 59 and 63 where two buns were produced).

TABLE 7

Example	ASAP 1100 (pbw)	Absorption	Retention
39	0	11.8	8.2
40	15	27.5	20.6
41	20	28.8	22.9
42	25	37.4	29.1
43	30	41.0	32.4
44	35	44.1	35.6
45	40	43.8	35.3
46	45	43.8	35.9
47	50	42.5	35.5
48	55	43.1	36.1
49	60	44.3	36.7
50	65	41.2	34.7
51	70	41.5	35.1
52	75	41.6	34.5
53	80	42.8	35.8
54	85	43.2	37.0
55	90	43.0	36.4
56	95	41.5	33.3
57	100	42.0	35.75

Each foam bun was cut to provide ten samples having the following dimensions: 3" x 5" x ½". Thus, for a given composition thirty samples were made for testing (i.e. 3 buns x 10 samples/bun = 30 samples), except Examples 59 and 63 where twenty samples were made for testing (i.e. 2 buns x 10 samples/bun = 20 samples). The water absorption and retention properties of each of the thirty samples was assessed using the absorption and retention protocols described above. The aqueous liquid was water and the immersion time was 60 minutes. The results, reported for each Example as

the average absorption and retention, respectively, for the all of the samples of the Example, are provided in Table 9 (i.e. the average of the average absorption and retention for each lot of ten samples from a given foam bun).

5

TABLE 8

Ingredient	Amount (pbw)
IM4000	35.0
B8202	1.3
Z65	0.5
DABCO-T16	0.05
H ₂ O	2.8
TDI 80	Amount sufficient to achieve an isocyanate index of about 1.05

10

15

TABLE 9

Example	CP1421/3010 (pbw)	Absorption	Retention
58	0/100	10.9	9.7
59	65/35	35.7	28.7
60	70/30	36.5	29.7
61	75/25	40.2	32.5
62	80/20	40.0	31.6
63	85/15	33.7	25.9

20

As will be apparent to those of skill in the art, Example 58 contains no hydrophilic polyol and is provided for comparison purposes only. The results, inter alia, clearly demonstrate that the foams produced in Examples 59-63 exhibit significantly improved absorption and retention properties compared to a foam which does not contain a hydrophilic polyol (Example 58).

EXAMPLES 64-69

The methodology used in Examples 58-63 was repeated for these Examples using the formulation in Table 8, with the exception that the hydrophilic polyol used was Pluracol 593. The relative amounts of hydrophilic polyol (593) and non-hydrophilic polyol (3010) are reported in Table 10, together with results of absorption and retention testing (note: two foam buns were produced in Example 64 and three foam buns were produced in each of Examples 65-69).

TABLE 10

Example	593/3010 (pbw)	Absorption	Retention
64	0/100	6.9	6.2
65	60/40	29.9	24.7
66	65/35	32.0	26.4
67	70/30	34.6	28.6
68	75/25	35.2	29.3
69	80/20	36.8	30.0

As will be apparent to those of skill in the art, Example 64 contains no hydrophilic polyol and is provided for comparison purposes only. The results, inter alia, clearly demonstrate that the foams produced in Examples 65-69 exhibit significantly improved absorption and retention properties compared to a foam which does not contain a hydrophilic polyol (Example 64).

EXAMPLES 70-76

The methodology used in Examples 58-63 was repeated for these Examples using the formulation in Table 8, with the exception that the hydrophilic polyol used was Arcol 2580. The relative amounts of hydrophilic polyol (Arcol 2580) and non-hydrophilic polyol (3010) are reported in Table 11, together with results of absorption and retention testing (note: two foam buns were produced in Example 71 and three foam buns were produced in each of Examples 70 and 72-76).

TABLE 11

Example	Arco 2580/3010 (pbw)	Absorption	Retention
70	0/100	11.7	10.6
71	50/50	25.9	22.7
72	55/45	31.7	26.6
73	60/40	33.1	27.6
74	65/35	39.3	31.5
75	70/30	38.5	31.4
76	75/25	38.4	29.5

As will be apparent to those of skill in the art, Example 70 contains no hydrophilic polyol and is provided for comparison purposes only. The results, inter alia, clearly demonstrate that the foams produced in Examples 71-76 exhibit significantly improved absorption and retention properties compared to a foam which does not contain a hydrophilic polyol (Example 70).

EXAMPLES 77-90

A number of commercially available personal hygiene products (i.e. disposable diapers, tampons/feminine pads, incontinence pads and incontinence devices) were tested to determine their ability to absorb and retain water.

The following general testing procedure was utilized. The dry weight of the product was determined, after which it was subject to immersion in

water and absorption and retention test as described herein above for the various polyurethane foam products. The results of absorption and retention testing are provided in Table 12.

5

TABLE 12

Example	Personal Hygiene Product	Absorption	Retention
77	Luvs™ For Boys & Girls	32.3	27.9
78	Food Lion Ultras For Girls	25.8	23.4
79	Huggies™ Ultratrim For Girls	41.3	36.2
10 80	Pampers™ Trainers	17.6	14.9
81	Unicharm™ Diapers For Girls	35.5	29.8
82	Pull-up Goodnites™	27.8	25.7
83	Unicharm™ Adult Incontinence	46.6	41.8
84	Sentress™ Nitetime Pad	12.8	8.0
15 85	Stay Free™ Ultra Thin Plus	9.8	7.3
86	Depend™ Poise	33.2	29.3
87	Depend™ Guards For Men	28.4	23.5
88	Affirm™ Contra Pads	20.1	18.4
89	Tampax™ Satin Touch	15.1	7.6
20 90	Sentress™ Superabs. Tampon	6.9	4.3

These results demonstrate that various of the present polyurethane foams exemplified above exhibit water absorption and retention properties which are similar to or exceed those of various commercially available personal hygiene devices. It is contemplated that the present polyurethane foam can be used to replace the absorbent core of these personal hygiene

25

devices to provide lighter devices having enhanced water absorbance and retention properties.

EXAMPLE 91

- 5 In this Example, a polyurethane foam in accordance with the present invention was prepared using a filler material (RRIM). The formulation used is provided in Table 13.

TABLE 13

10	<table><tr><th>Ingredient</th><th>Amount (pbw)</th></tr><tr><td>CP1421</td><td>75.0</td></tr><tr><td>VORANOL 3010</td><td>25.0</td></tr><tr><td>RRIM</td><td>10.0</td></tr><tr><td>IM4000</td><td>40.0</td></tr><tr><td>15 B8202</td><td>1.5</td></tr><tr><td>Z65</td><td>0.5</td></tr><tr><td>DABCO-T16</td><td>0.05</td></tr><tr><td>H₂O</td><td>2.8</td></tr><tr><td>TDI 80</td><td>Amount sufficient to achieve an isocyanate index of about 1.05</td></tr></table>	Ingredient	Amount (pbw)	CP1421	75.0	VORANOL 3010	25.0	RRIM	10.0	IM4000	40.0	15 B8202	1.5	Z65	0.5	DABCO-T16	0.05	H ₂ O	2.8	TDI 80	Amount sufficient to achieve an isocyanate index of about 1.05
Ingredient	Amount (pbw)																				
CP1421	75.0																				
VORANOL 3010	25.0																				
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Z65	0.5																				
DABCO-T16	0.05																				
H ₂ O	2.8																				
TDI 80	Amount sufficient to achieve an isocyanate index of about 1.05																				
20																					

- The foam was prepared by blending the two polyols with the catalyst and water blowing agent to which was added the RRIM and the superabsorbent material with adequate agitation to provide a uniform mixture. Thereafter, the isocyanate was added to the uniform mixture. The reaction mixture was poured into an open container and allowed to expand to result in a polyurethane foam bun having the following dimensions: 9" x 9.5" x 4".
- 25

For a given composition, the procedure was carried out three times so that a total of three foam buns were produced for each Example.

Each foam bun was cut to provide ten samples having the following dimensions: 3" x 5" x ½". Thus, thirty samples were made for testing. The water absorption and retention properties of each of the thirty samples was assessed using the absorption and retention protocols described above. The aqueous liquid was water and the immersion time was 60 minutes.

The average absorption of the ten lot samples from each bun was determined to be: 42.9, 44.3 and 33.6, respectively (average: 40.3). The average retention of the ten lot samples from each bun was determined to be: 32.3, 33.1 and 24.7, respectively (average 30.0).

The results, inter alia, clearly demonstrate that it is possible to produce a filled foam within the scope of the invention without any significant compromise of the ability of the foam to maintain its water absorption and retention properties.

EXAMPLE 92

A number of commercially available personal hygiene products were tested for water absorption in direct comparison with two polyurethane foams in accordance with the present invention. The polyurethane foams were prepared according the formulation provided in Table 14 using the procedure described above in Examples 15-38.

In this Example, the following products were tested:

25	<u>Designation</u>	<u>Product</u>
	A	Foam produced using formulation in Table 14 including 25 pbw IM4500
	B	Foam produced using formulation in Table 14 including 50 pbw IM4500
30	H	Huggies™ Ultra Trim For Girls (diaper product)
	K	Kotex™ Occasions (feminine hygiene product)

TABLE 14

Ingredient	Amount (pbw)
Arco 2580	75.0
VORANOL 3010	25.0
L5770	1.2
C255	1.0
DABCO-T16	0.1
H ₂ O	2.8
TDI 80	Amount sufficient to achieve an isocyanate index of about 1.05

These products were tested for water absorption over the following periods: 1 minute, 5 minutes, 10 minutes, 20 minutes and 30 minutes. The testing protocol for the commercially available personal hygiene products was that described above in Examples 77-90, modified to reduce the period of immersion in water. The testing protocol for the polyurethane foam was that described above in Examples 15-38, modified to reduce the period of immersion in water.

The results are illustrated graphically in Figure 1. The designations of A, B, H and K shown in Figure 1 correspond to those referred to above.

EXAMPLE 93

Example 92 was repeated with the exception that the fluid used in the testing protocol was 0.9% saline.

The results are illustrated in Figure 2. These results are surprising in that absorption properties of polyurethane foam B relative to Huggies™

Ultratrim For Girls were significantly different from those reported in Example 92. Specifically, a surprising and unexpected significant increase in absorption properties can be seen for polyurethane foam B. This suggests that, when moving from water absorption to saline absorption there is a relative increase in fluid absorption by polyurethane foam B compared with Huggies™ Ultratrim For Girls. This unexpected result renders a foam such as polyurethane foam B a suitable candidate for use in a device intended to absorb urine and other salt-based fluids (e.g. diapers).

10 EXAMPLE 94

The commercially available personal hygiene products and polyurethane foams referred to in Examples 93 and 94 were subjected to a strike through test to determine absorption rate. Additionally, a sample of Huggies™ Ultra Trim For Girls diapers was modified to remove the top sheet - this sample is designated HwoTS in this Example. The designations of A, B and H used in this Example are the same as referred to above in Example 93.

Polyurethane foams A and B were placed in a conventional diaper construction. Thus, all samples tested in this Example were in the form of diaper constructions.

The following testing protocol was used. The test diaper was laid flat and a striking device was aligned target zone of the diaper. The striking device consisted of a 2 inch I.D. plexiglass cylinder installed on a base stand. A sample of 100 mL of 0.9% saline solution was poured into the striking device. The time required for the saline to be dispersed from the striking device (i.e. become absorbed by the diaper surface) was recorded - this is referred to as INSULT 1. For each test diaper, two further insults, INSULT 2 and INSULT 3, were conducted in a similar manner. As is known to those of skill in the art, the shorter the period for completing absorption of an insult, the better the absorption rate of the test diaper.

The results of these strike through tests are illustrated graphically in Figure 3. These results are surprising and unexpected. Specifically, with

- reference to polyurethane foams A and B, the period for completing multiple insults decreased or remained substantially the same, and was recorded at or below approximately 6 seconds. In contrast, the period for completing multiple insults on samples H and HwoTS increased with successive insults, and was recorded at approximately 11 seconds up to approximately 28 seconds for sample HwoTS and approximately 13 seconds up to approximately 27 seconds for sample H. These results demonstrate that polyurethane foams A and B are superior to Huggies™ Ultra Trim For Girls in strike through absorption rate.
- 5

What is claimed is:

1. A foamed isocyanate-based polymer having a cellular structure and containing a superabsorbent material, the polymer being capable of:
5 absorbing at least about 20 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining at least about 20 times its weight of absorbed aqueous fluid which is bound to the superabsorbent material.
- 10 2. A foamed isocyanate-based polymer defined in claim 1, wherein the polymer is capable of: (i) absorbing from about 20 to about 100 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining from about 20 to about 90 times its weight of absorbed aqueous fluid which is bound to the superabsorbent material.
- 15 3. A foamed isocyanate-based polymer defined in claim 1, wherein the polymer is capable of: (i) absorbing from about 20 to about 80 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining from about 20 to about 70 times its weight of
20 absorbed aqueous fluid which is bound to the superabsorbent material.
4. A foamed isocyanate-based polymer defined in claim 1, wherein the polymer is capable of: (i) absorbing from about 35 to about 65 times its weight of an aqueous fluid maintained at a temperature of from about 20° to
25 about 25°C, and (ii) retaining from about 30 to about 55 times its weight of absorbed aqueous fluid which is bound to the superabsorbent material.
5. A foamed isocyanate-based polymer defined in claim 1, wherein the
30 superabsorbent material is a synthetic polymer.

6. A foamed isocyanate-based polymer defined in claim 1, wherein the superabsorbent material is a cellulosic polymer.
7. A foamed isocyanate-based polymer defined in claim 6, wherein the
5 cellulosic polymer is a carboxymethyl cellulose.
8. A foamed isocyanate-based polymer defined in claim 1, wherein the superabsorbent material is a polymer of at least one of an acrylic monomer and vinyl monomer.
- 10
9. A foamed isocyanate-based polymer defined in claim 1, wherein the superabsorbent material is selected from the group consisting of polyvinylpyrrolidone, sulfonated polystyrene, polysulfethyl acrylate, poly(2-hydroxyethylacrylate), polyacrylamide, polyacrylic acid, poly(acrylic acid
15 alkali metal salt), starch modified polyacrylic acid, poly(starch modified acrylic acid alkali metal salt), hydrolyzed polyacrylonitrile, poly(hydrolyzed polyacrylonitrile alkali metal salt) and mixtures thereof.
- 20
10. A foamed isocyanate-based polymer defined in claim 1, wherein the superabsorbent material is present in an amount up to about 150 parts by weight per hundred parts by weight of active hydrogen-containing compound used to produce the foamed isocyanate-based polymer.
- 25
11. A foamed isocyanate-based polymer defined in claim 1, wherein the superabsorbent material is present in the range of from about 20 to about 110 parts by weight per hundred parts by weight of active hydrogen-containing compound used to produce the foamed isocyanate-based polymer.
- 30
12. A foamed isocyanate-based polymer defined in claim 1, wherein the superabsorbent material is present in the range of from about 35 to about 75 parts by weight per hundred parts by weight of active hydrogen-containing compound used to produce the foamed isocyanate-based polymer.

13. A foamed isocyanate-based polymer defined in claim 1, wherein the superabsorbent material is present in the range of from about 55 to about 65 parts by weight per hundred parts by weight of active hydrogen-containing compound used to produce the foamed isocyanate-based polymer.

5

14. A foamed polyurethane polymer comprising poly(acrylic acid alkali metal salt) in an amount in the range of from about 55 to about 65 parts by weight per hundred parts by weight of polyol used to produce the foamed polyurethane polymer, the polymer being capable of: (i) absorbing from
10 about 35 to about 65 times its weight of an aqueous fluid maintained at a temperature of from about 20° to about 25°C, and (ii) retaining from about 30 to about 55 times its weight of absorbed aqueous fluid which is bound to the poly(acrylic acid alkali metal salt).

15 15. A process for producing a foamed isocyanate-based polymer comprising the steps of:

providing a substantially uniform mixture comprising an isocyanate, an active hydrogen-containing compound and a superabsorbent material, the superabsorbent material being capable of absorbing at least about 20 times its
20 weight of an aqueous fluid maintained at a temperature in the range of from about 20° to about 25°C;

adding to the substantially uniform mixture an aqueous blowing agent and a catalyst to form a reaction mixture; and

expanding the reaction mixture to produce the foamed isocyanate-based
25 polymer;

wherein the active hydrogen-containing compound comprises from about 10% to 100% by weight of a hydrophilic active hydrogen-containing compound and from 0 to about 90% by weight a non-hydrophilic active hydrogen-containing compound.

30

16. The process defined in claim 15, wherein the active hydrogen-containing compound comprises from about 20% to about 90% by weight of

a hydrophilic active hydrogen-containing compound and from about 10% to about 80% by weight a non-hydrophilic active hydrogen-containing compound.

17. The process defined in claim 15, wherein the active hydrogen-
5 containing compound comprises from about 40% to about 90% by weight of a hydrophilic active hydrogen-containing compound and from about 10% to about 60% by weight a non-hydrophilic active hydrogen-containing compound.
18. The process defined in claim 15, wherein the active hydrogen-
10 containing compound comprises from about 70% to about 80% by weight of a hydrophilic active hydrogen-containing compound and from about 20% to about 30% by weight a non-hydrophilic active hydrogen-containing compound.
19. The process defined in claim 15, wherein the hydrophilic active
15 hydrogen-containing compound is a hydrophilic polyol.
20. The process defined in claim 19, wherein the hydrophilic polyol is selected from the group consisting of diols, triols and tetrols containing polyoxyalkylene groups, the polyoxyalkylene groups comprising at least 25
20 percent by weight of ethylene oxide.
21. The process defined in claim 15, wherein the non-hydrophilic active hydrogen-containing compound is selected from the group consisting of non-hydrophilic polyols, polyamines, polyamides, polyimines, polyolamines and
25 mixtures thereof.
22. The process defined in claim 15, wherein the non-hydrophilic polyol is a hydroxyl-terminated compound selected from the group consisting of polyether, polyesters, polycarbonate, polydiene, polycaprolactone and
30 mixtures thereof.

23. The process defined in claim 15, wherein the non-hydrophilic polyol is selected from the group consisting of adipic acid-ethylene glycol polyester, poly(butylene glycol), poly(propylene glycol), hydroxyl-terminated polybutadiene and mixtures thereof.

5

24. The process defined in claim 22, wherein the non-hydrophilic polyol is a polyether polyol.

25. The process defined in claim 24, wherein the polyether polyol has a
10 molecular weight in the range of from about 200 to about 10,000.

26. The process defined in claim 15, wherein the active hydrogen-containing compound is a polyamine or a polyalkanolamine.

15 27. The process defined in claim 26, wherein the polyamine is selected from the group comprising primary and secondary amine terminated polyethers.

28. The process defined in claim 15, wherein the isocyanate is represented
20 by the general formula:



wherein i is an integer of two or more and Q is an organic radical having the
25 valence of i.

29. The process defined in claim 15, wherein the isocyanate is selected from the group comprising 1,6-hexamethylene diisocyanate, 1,4-butylene diisocyanate, furfurylidene diisocyanate, 2,4-toluene diisocyanate, 2,6-toluene diisocyanate, 2,4'-diphenylmethane diisocyanate, 4,4'-diphenylmethane diisocyanate, 4,4'-diphenylpropane diisocyanate, 4,4'-diphenyl-3,3'-dimethyl methane diisocyanate, 1,5-naphthalene diisocyanate, 1-methyl-2,4-

30

diisocyanate-5-chlorobenzene, 2,4-diisocyanato-s-triazine, 1-methyl-2,4-diisocyanatocyclohexane, p-phenylene diisocyanate, m-phenylene diisocyanate, 1,4-naphthalene diisocyanate, dianisidine diisocyanate, bitolylene diisocyanate, 1,4-xylylene diisocyanate, 1,3-xylylene diisocyanate, bis-(4-
5 isocyanatophenyl)methane, bis-(3-methyl-4-isocyanatophenyl)methane, polymethylene polyphenyl polyisocyanates and mixtures thereof.

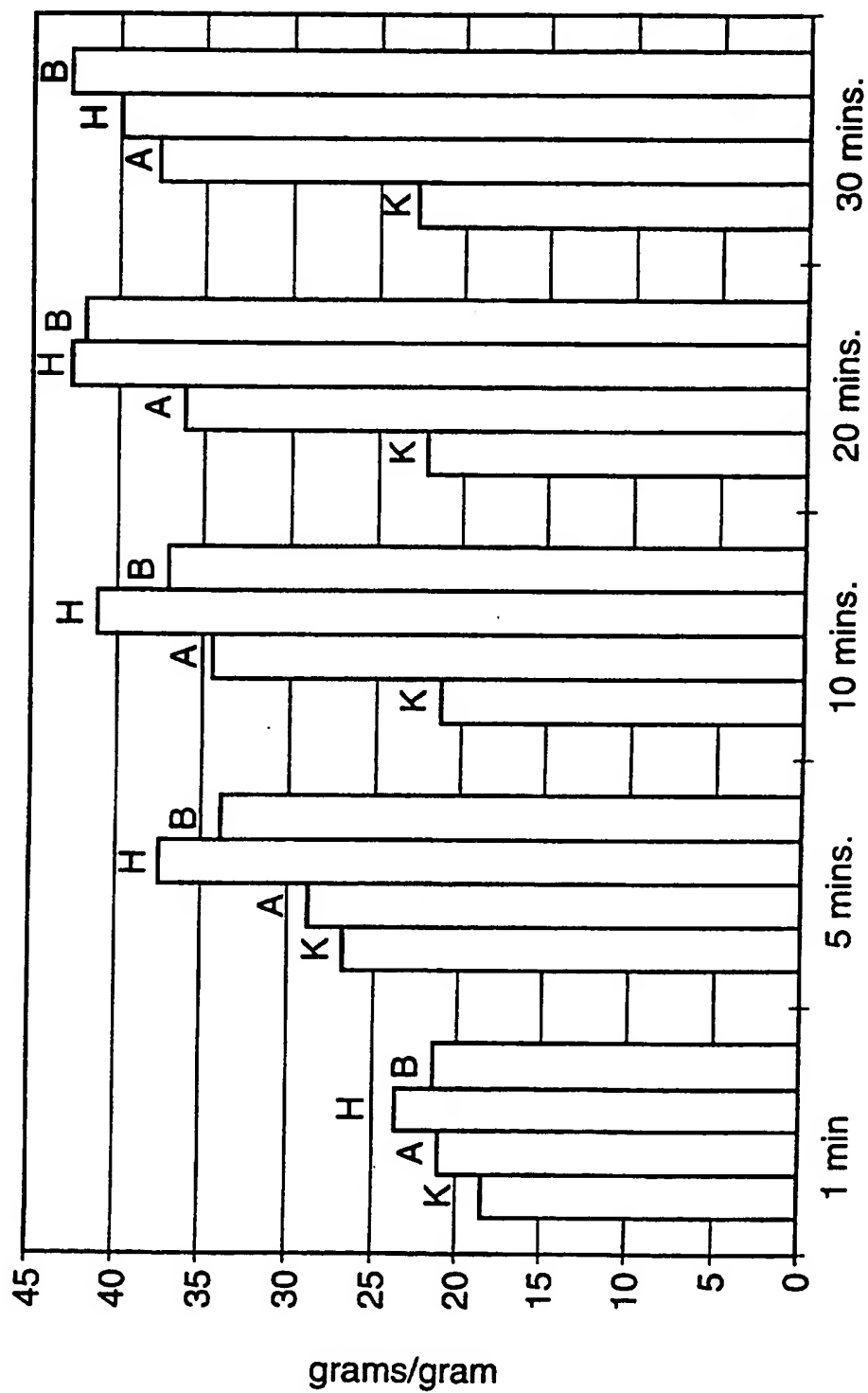
30. The process defined in claim 15, wherein the isocyanate is selected from the group comprising 2,4-toluene diisocyanate, 2,6-toluene diisocyanate
10 and mixtures thereof.

31. The process defined in claim 15, wherein the isocyanate is selected from the group consisting essentially of (i) 2,4'-diphenylmethane diisocyanate, 4,4'-diphenylmethane diisocyanate and mixtures thereof; and (ii) mixtures of
15 (i) with an isocyanate selected from the group comprising 2,4-toluene diisocyanate, 2,6-toluene diisocyanate and mixtures thereof.

32. A personal hygiene device having a bodily fluid absorbent layer consisting essentially of the foamed isocyanate-based polymer defined in claim
20 1.

33. A personal hygiene device having a bodily fluid absorbent layer consisting essentially of the foamed polyurethane polymer defined in claim 14.

1/3



Time

FIG.1

2/3

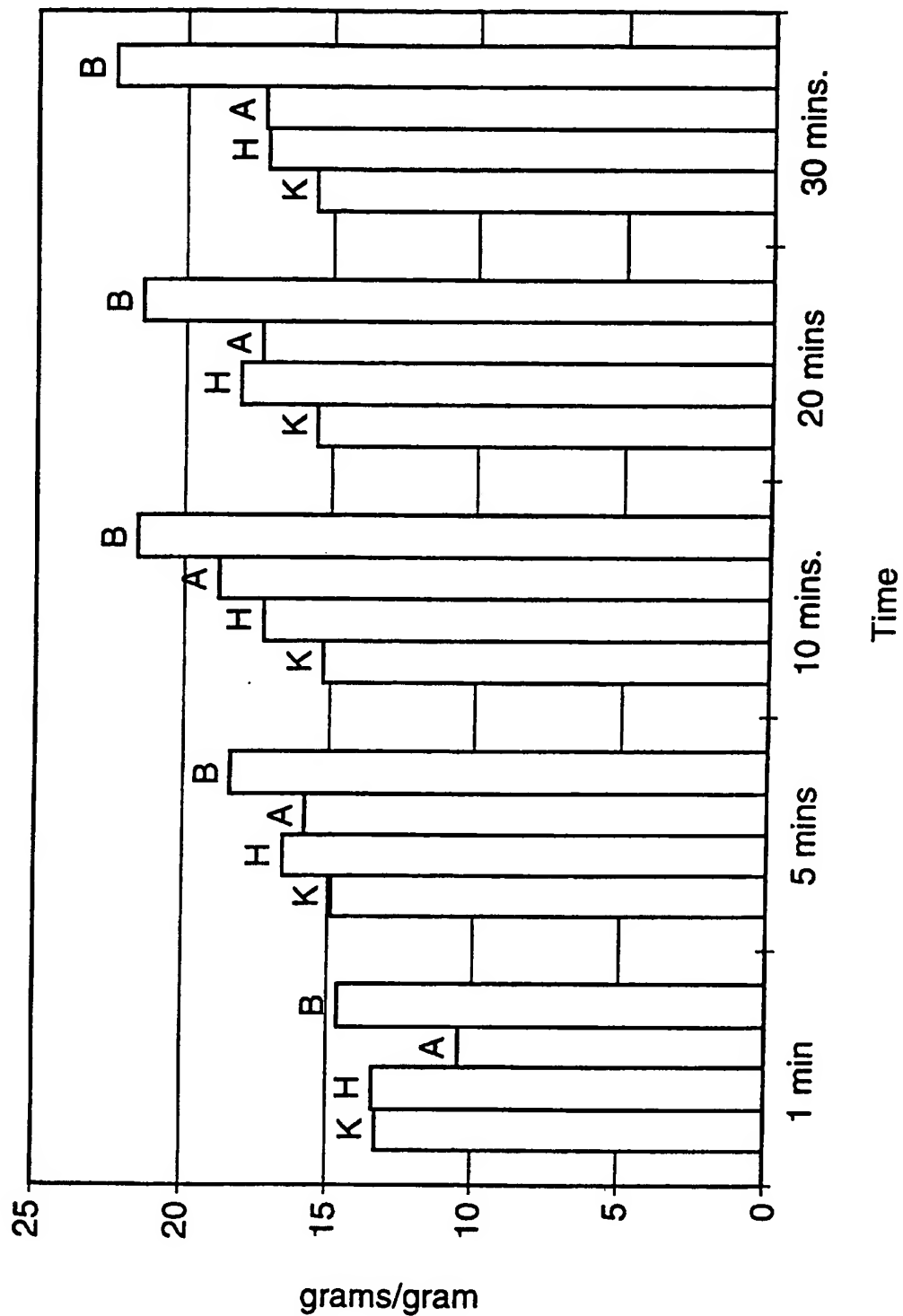


FIG.2

3/3

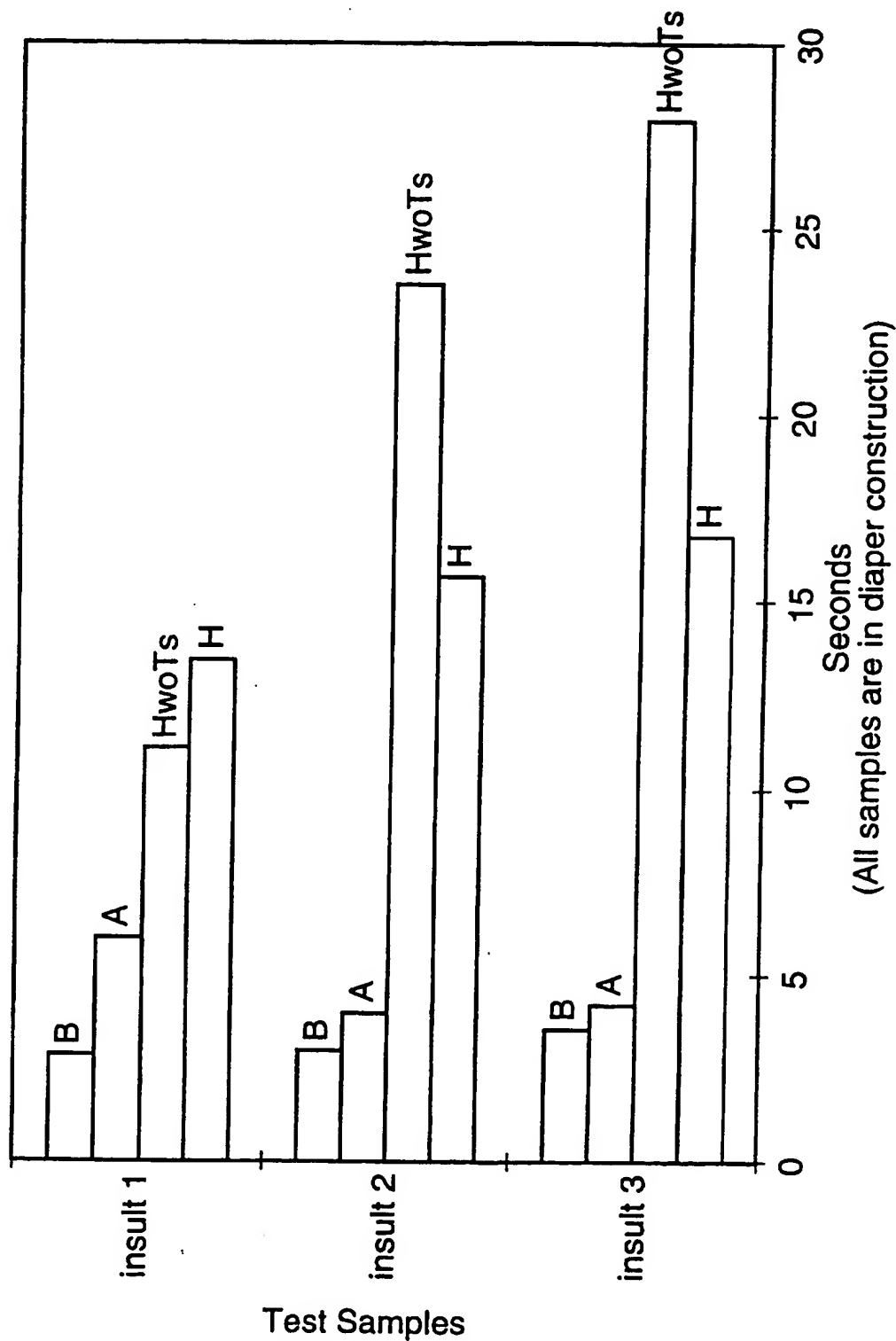


FIG.3

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